

Date: Monday, 27/04/2009 12:49:09 PM  
 User: Julie Dawson

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 47496	
Estimate Number : 13009	
P.O. Number :	Part Number : D3245042
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3245 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 45856	Material :
Written By :	Due Date : 12/05/2009 Qty: 5 Um: Each
Checked & Approved By : JLD 09.04.27	
Comment : Est Rev :A New Issue 07-09-11 JLM Verified By:EC	
Est Rev:b ECN 1052 07-10-31 DD verified by:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D32452	Panel
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Batch:

B46172(4x) B43902(2x)

3.0	D32455	Door
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Angle Plate

Batch:

B43768(4x) B46174(2x)

4.0	235018C3Y	RIGID RECEPTACLE
-----	-----------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

RIGID RECEPTACLE

Batch:

M108722(33x) M111129(15x)

5.0	MS20427M33	Rivet
-----	------------	-------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Rivet

Batch:

M110022

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 27/04/2009 12:49:09 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 47496

Part Number: D3245042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20615M33

Rivet



27/04/28

Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)  
Rivet

118235 (4x)

M108558

(50x)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245  
be careful when countersinking...mat'l very thin

8.0

QC5

INSPECT WORK TO CURRENT STEP



27/04/28 (5)

Comment: INSPECT WORK TO CURRENT STEP

2096662 (x5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock  
Location: 234

9663

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/03 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09.06.03



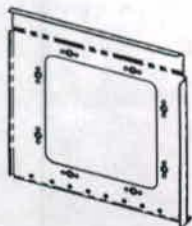
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

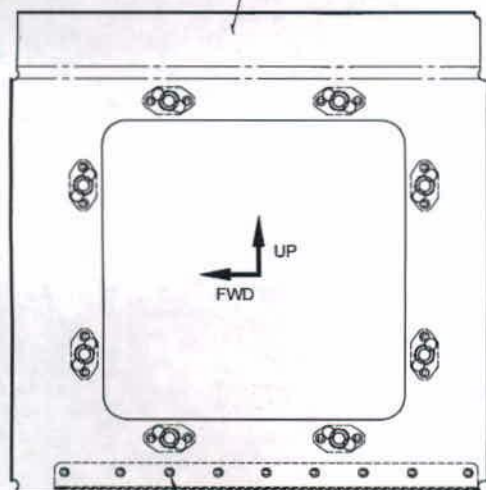
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



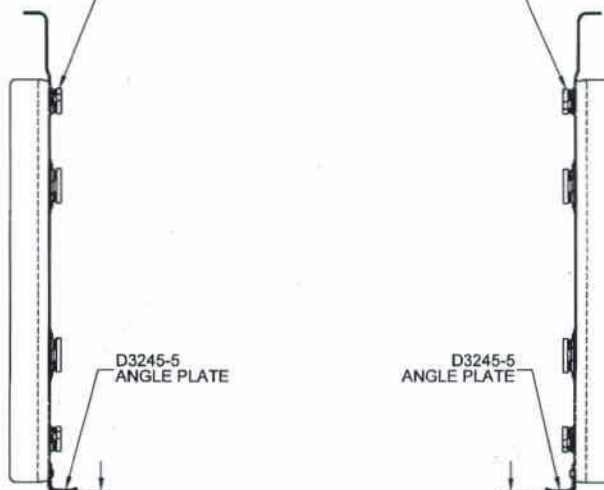
D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

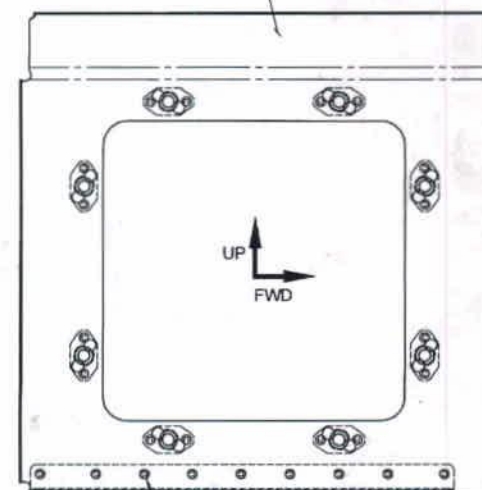
**D3245-041 ACCESS PANEL ASSEMBLY**



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

**RELEASED**  
14 07-10-23

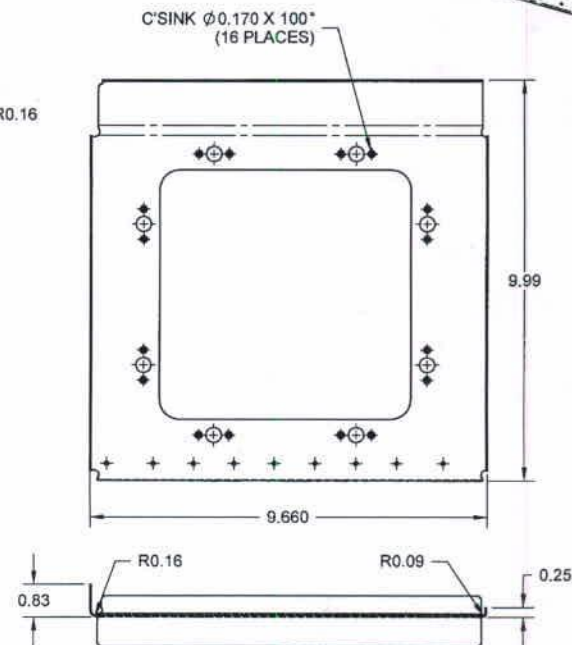
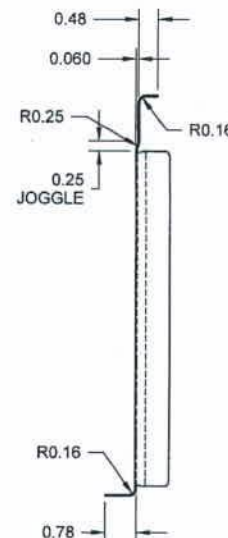
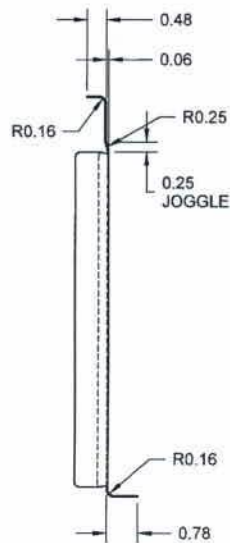
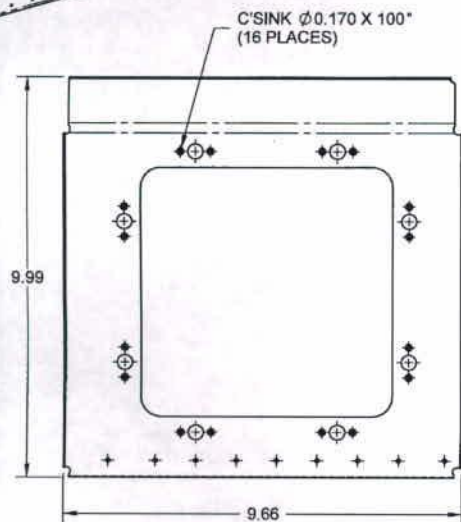
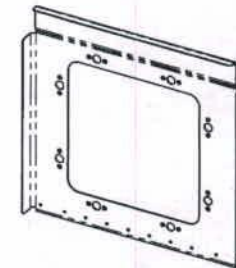
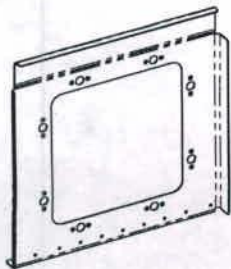
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.394 HOLES FROM D3245-1/-1F, REMOVE MS21060-13K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.02		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3245</b>	REV. B
TITLE <b>ACCESS PANEL ASSEMBLY</b>	SHEET 1 OF 7
SCALE 1:2.5	
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D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED  
07-10-23

NOTES:

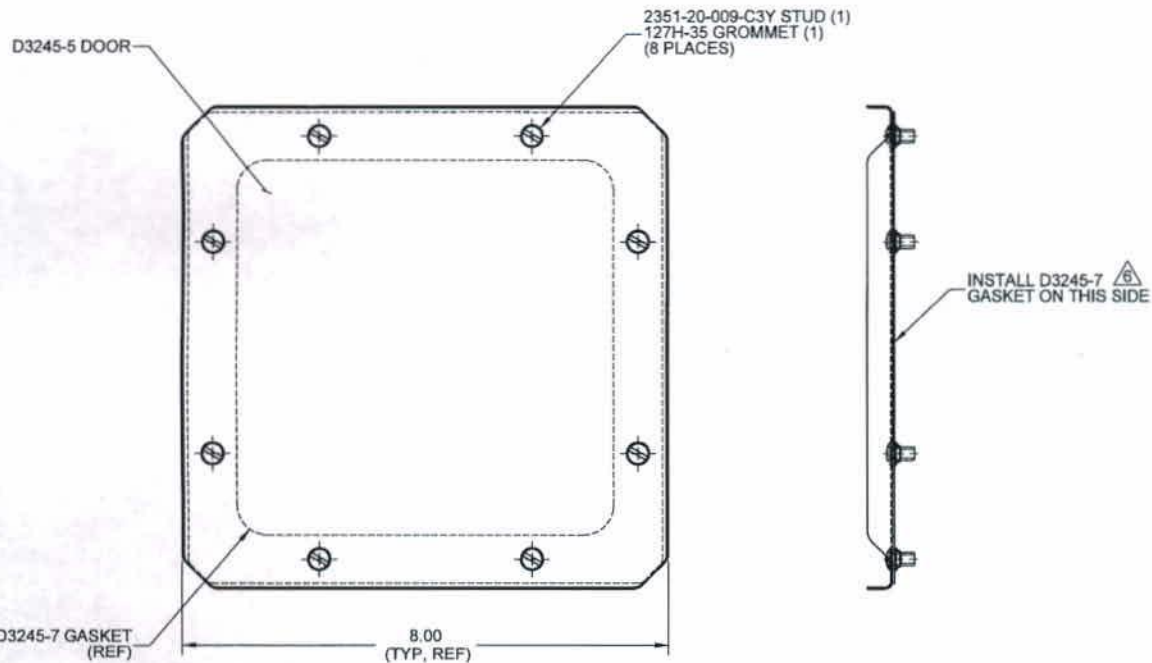
- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	TH	DART AEROSPACE LTD	
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CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	TH	D3245	SHEET 2 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSEMBLY	1:3
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8 7 6 5 4 3 2 1



**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

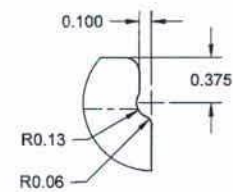
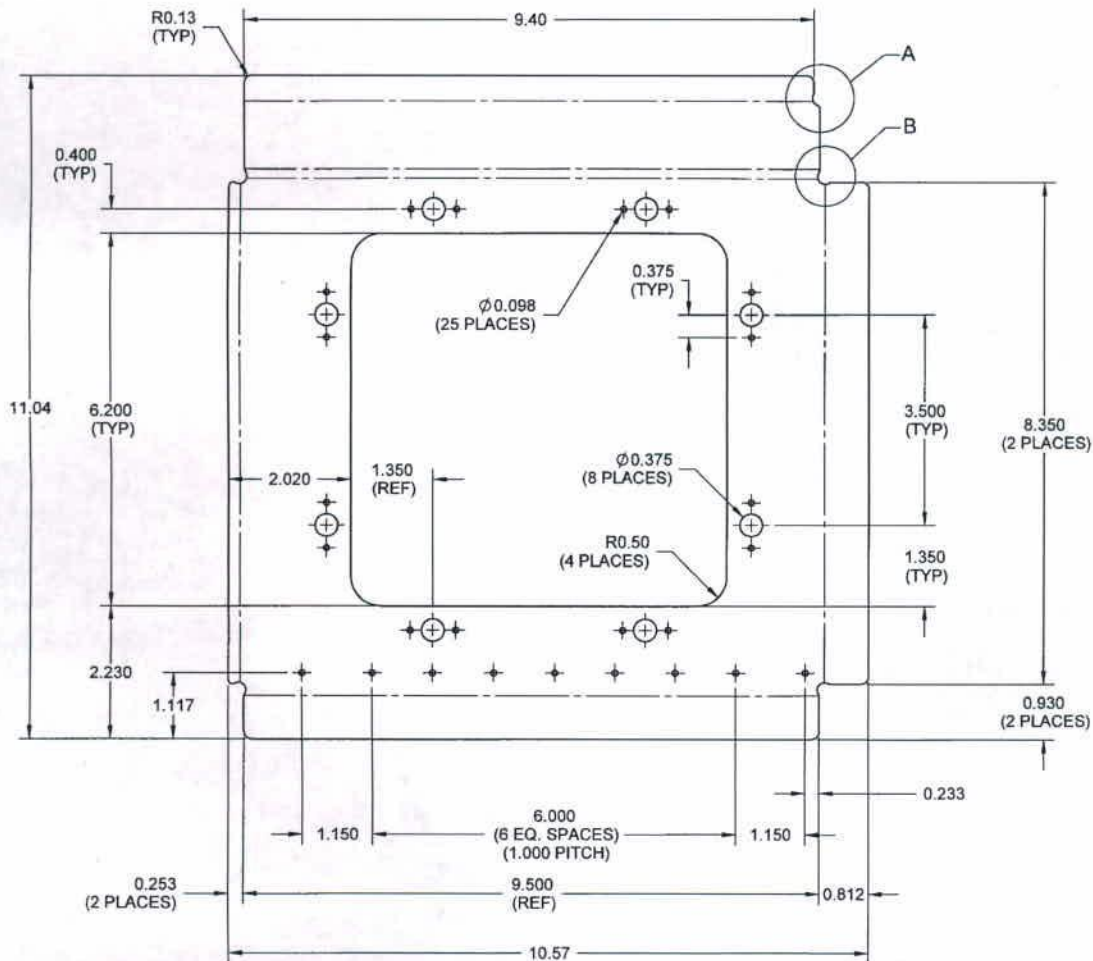
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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APPROVED		SCALE <b>1:2</b>
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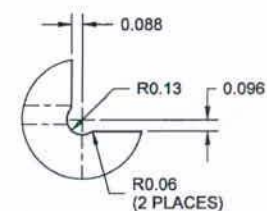
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**ORDER**

7 6 5 4 3 2 1



**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
(TYP, 4 PLACES)  
SCALE 1:1

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

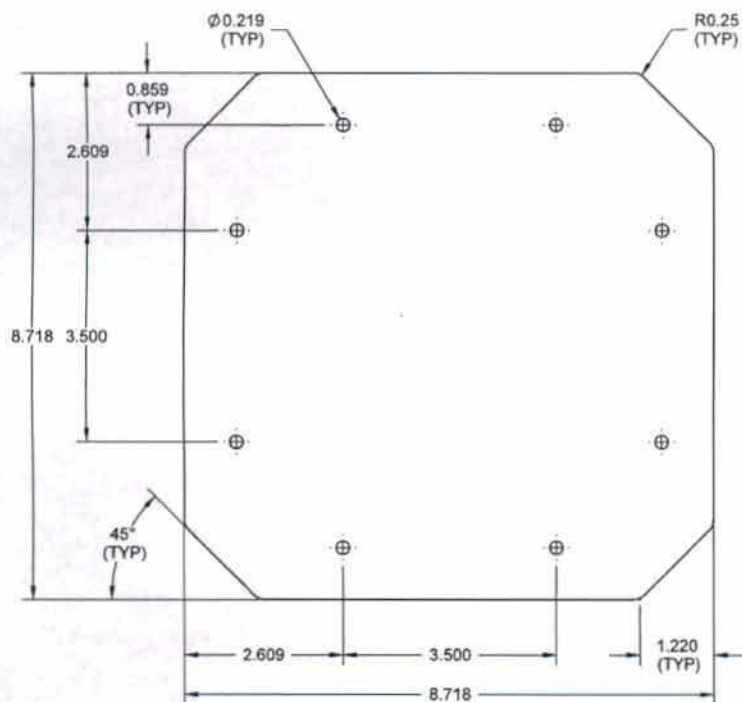
**D3245-1F PANEL FLAT PATTERN**

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	NS	D3245	SHEET 4 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
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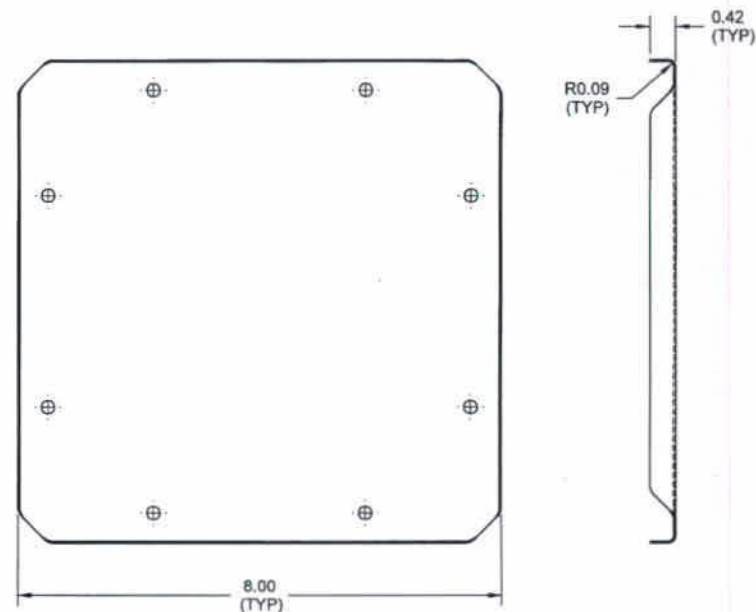
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**D3245-3F DOOR FLAT PATTERN**

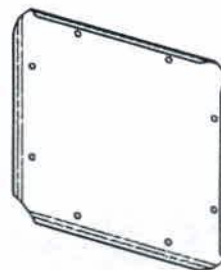


**D3245-3 DOOR BENDING DETAIL**

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



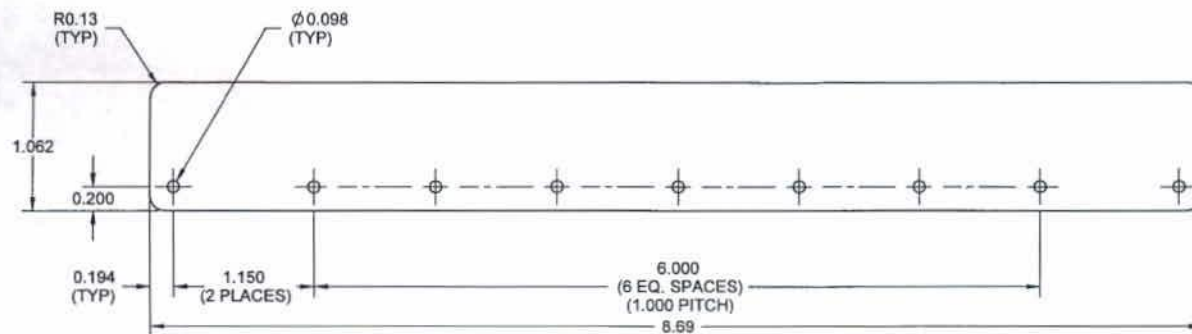
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 5 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
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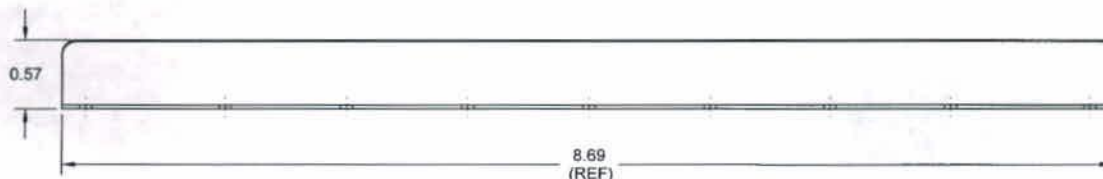
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D

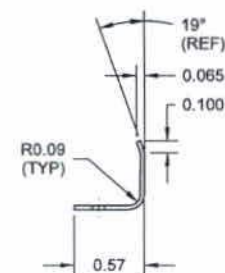
D



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)



**RELEASED**  
07.10.13

**NOTES:**

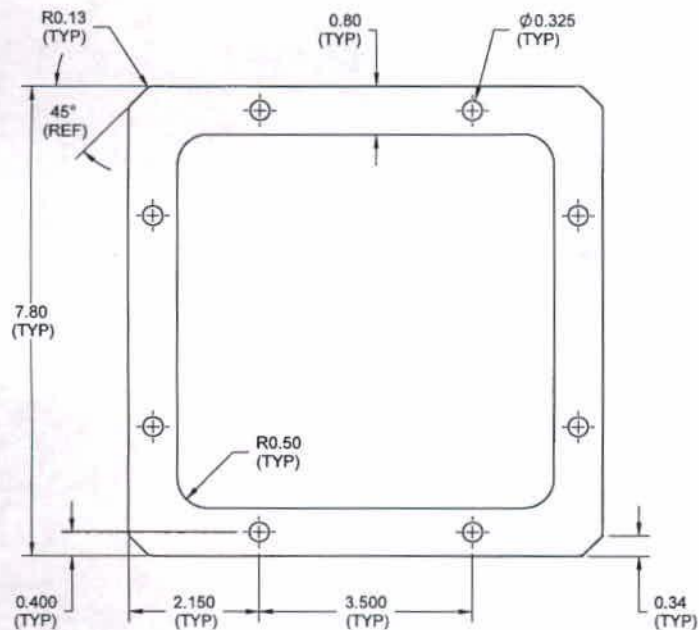
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF, DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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MFG. APPR.		D3245	SHEET 6 OF 7
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DE APPR.		ACCESS PANEL ASSEMBLY	1:1
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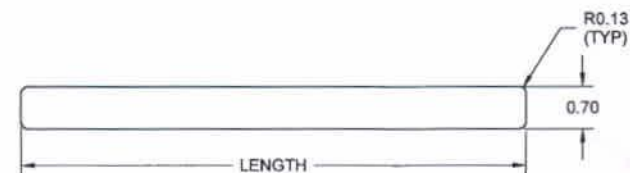
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A



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN		<b>DART AEROSPACE LTD</b>
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CHECKED		DRAWING NO. <b>D3245</b>
MFG. APPR.		REV. B
APPROVED		SHEET 7 OF 7
DE APPR.		TITLE <b>ACCESS PANEL ASSEMBLY</b>
DATE	07.10.02	SCALE 1:2

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